

Work Order ID 133183

Tuesday, May 26, 2015 12:50:18 PM

133183

Page 1

Item ID: D3561-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seal Insert Tool
 Start Date: 5/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: MAY 27 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3561	Rev A

100

0.00

100

Waterjet

FLOW CNC Waterjet

304.125

FLOW WATER JET

Memo

1-Cut as per Dwg D3561 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

4 Ø Jm15-6-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

4 Ø Jm15-6-2

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

(4) Ø Jm15-6-2

DAG
38
9-89
JUN 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

Page 2

Quality Control

JUN 08 2015

JUN 08 2015

DAS
38
9-89

JUN 09 2015

DQA: _____ Date: _____



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Work Order ID 133183

133183

Page 3

Tuesday, May 26, 2015 12:50:18 PM

Item ID: D3561-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Seal Insert Tool

Start Date: 5/26/15 Start Qty: 4.00 *4* Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>stop</u>	0.00				4		26 27	
160									
Packaging	Memo	0.00							
Packaging									
									JUN 10 2015
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							JUN 11 2015
Quality Control									
									MCS JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 26, 2015 12:50:18 PM

Page 1

Work Order ID: 133183

133183

Parent Item: D3561-1

D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A06.10.19New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

174.1917

0.0473

1

M304S11GA

Jm15-6-2

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

174.1917

122521

40.2

M128254

56

M129545

36.575

M129972

41.4167

129972

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

REV. A

DRAWING NO.

SHEET 1 OF 1

SCALE

1:1

TITLE
SEAL INSERT TOOL

DESCRIPTION

NEW ISSUE

DATE

06.10.06

REV.

A

DRAWN BY

APPROVED

CHECKED

DATE

06.10.06

DATE

06.10.06

REV.

A

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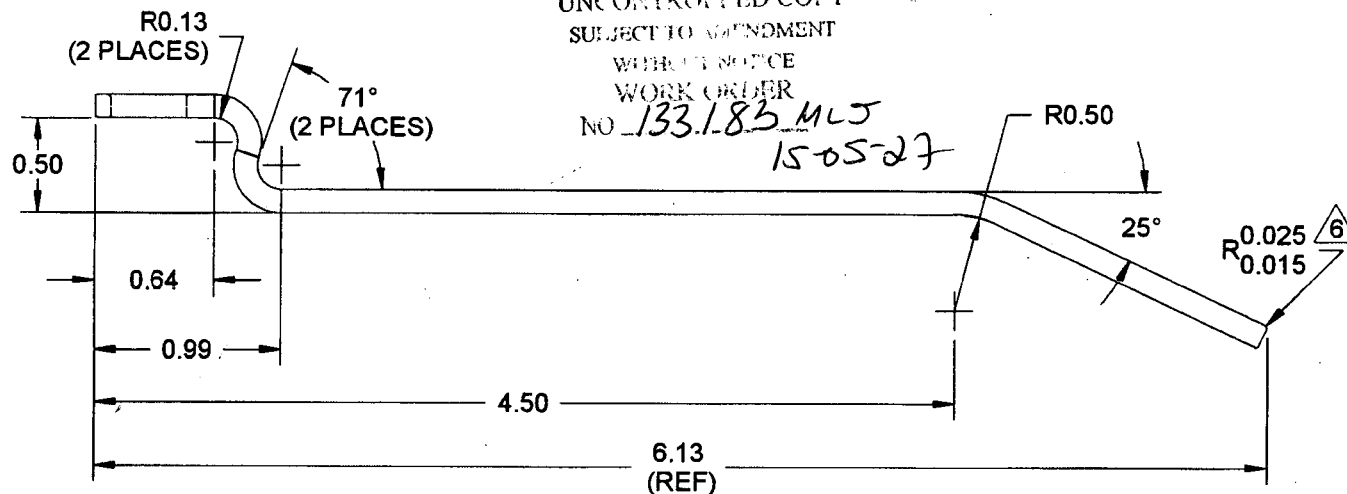
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WORK ORDER

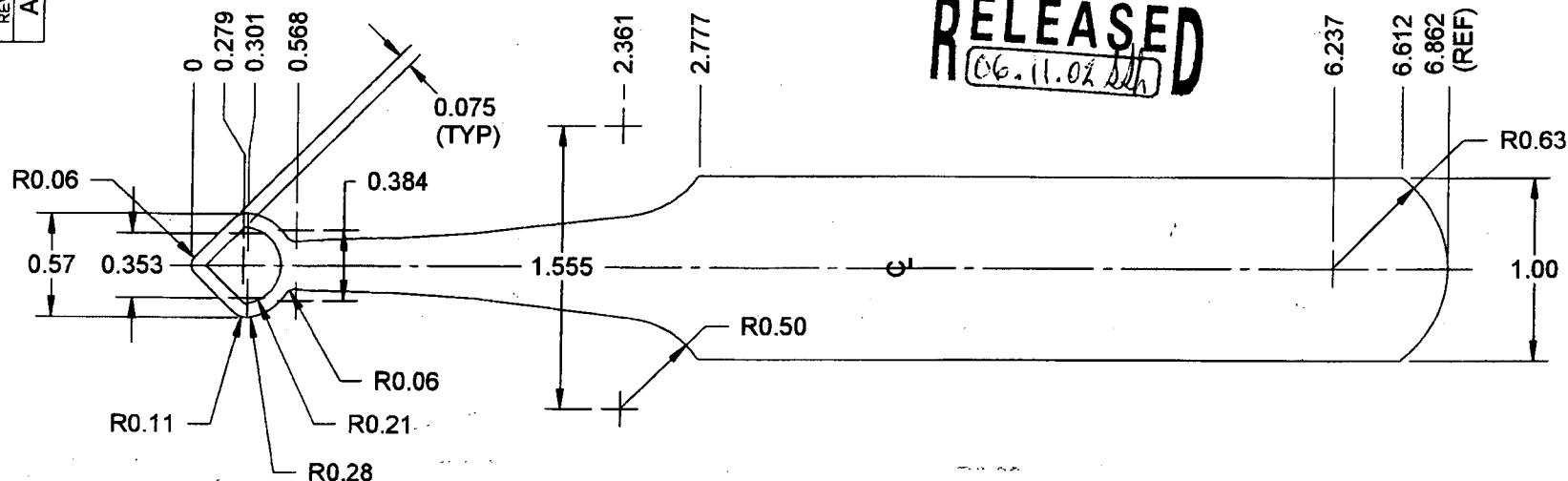
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D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

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